

Work Order ID 119343

Thursday, May 15, 2014 3:39:49 PM

119343

Page 1

Item ID: D3566-13

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Gasket Fwd

Stop

NS2

Start Date: 5/15/14

Start Qty: 24.00

24

Cust Item ID:

Required Date: 5/15/14

Req'd Qty: 24.00

24

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 14-05-21

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3566 | Rev C | | | | | | | | |

100

100

Waterjet

FLOW CNC Waterjet

700-063"

FLOW WATER JET

Memo

0.00

0.00

24 0 Jm14-05-29

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

0.00

24 0 Jm14-05-29

120

120

QC

Quality Control

QC8- Inspect parts - second check

0.00

0.00

DAS
17
89
W/S/C

24
CON

DQA:

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only

Work Order: _____

DISPOSITIONRework Scrap Use-as-is Suspected Unapproved Skid-tube Machining Thermoforming Large Fab **AGAINST DEPARTMENT/PROCESS**Crosstube Small Fab Finishing Composite Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier Engineering Quality Other

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| Landing Gear | General | Folio/Program | Outside Dimensions | Pressure/Forced |
|--------------------------|----------------------|-----------------------------------|----------------------|--------------------|
| Bending | Bend | Grain | Over/Under tolerance | Set-up |
| Centre Not Concentric | BOM/Route | Hardware | Part Incorrect | Temperature/Cure |
| Cracks | Broken/Damage/Defect | Inspection Incomplete/Unqualified | Part Lost/Missing | Weld |
| Crimp/Kink/Ripple/Wave | Burrs | Instructions Incomplete/Unclear | Part Moved | Wrong Stock Pulled |
| Cuffs | Contamination | Misaligned/off center | Positioned Wrong | |
| Crushing | Countersink | Mislabeled | Power Loss/Surge | |
| Heat Treat | Cut Too Short | Misread | | |
| Inspection Strip in Tube | Drawing | Off-set | | |
| Marks/Chatter | Drill Holes | Out of Calibration | | |
| Turning Sequence | Finish | Out of Sequence | | |
| Wave/Twist in Tube | Fit/Function | | | |

Work Order ID 119343

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119343

Page 2

Item ID: D3566-13

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Gasket Fwd

Stop

NS2

Start Date: 5/15/14 Start Qty: 24.00

24

Cust Item ID:

Required Date: 5/15/14 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: FP-001

0.00

130

Packaging

Packaging

Memo

0.00

24 x d M 1406103

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Quality Control

Memo

0.00

MLJ 1406-03

MLJ 14-06-03

DQA: _____ Date: _____

Date:

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Date:

Work Order update only



| Work Order: _____ | | | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | |
|--|--|---|--|--|--|--|--|---|--------------|--|--|
| | | | | Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> | Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> | Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> | Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> | | | |
| Part No. _____ | | | | | | | | | | | |
| NCR No. _____ | | | | | | | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | | |
| Design <input type="checkbox"/> | | | | | | | | | | | |
| Doc/Data <input type="checkbox"/> | | | | | | | | | | | |
| Equip/Tooling <input type="checkbox"/> | | | | | | | | | | | |
| Handling/Pre <input type="checkbox"/> | | | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | | | |
| Offset/Setup <input type="checkbox"/> | | | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | | | |
| Transport <input type="checkbox"/> | | | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | |
| Landing Gear | | | | General | | | | | | | |
| Bending <input type="checkbox"/> | Bend <input type="checkbox"/> | Folio/Program <input type="checkbox"/> | Outside Dimensions <input type="checkbox"/> | Pressure/Forced <input type="checkbox"/> | | | | | | | |
| Centre Not Concentric <input type="checkbox"/> | BOM/Route <input type="checkbox"/> | Grain <input type="checkbox"/> | Over/Under tolerance <input type="checkbox"/> | Set-up <input type="checkbox"/> | | | | | | | |
| Cracks <input type="checkbox"/> | Broken/Damage/Defect <input type="checkbox"/> | Hardware <input type="checkbox"/> | Part Incorrect <input type="checkbox"/> | Temperature/Cure <input type="checkbox"/> | | | | | | | |
| Crimp/Kink/Ripple/Wave <input type="checkbox"/> | Burrs <input type="checkbox"/> | Inspection Incomplete/Unqualified <input type="checkbox"/> | Part Lost/Missing <input type="checkbox"/> | Weld <input type="checkbox"/> | | | | | | | |
| Cuffs <input type="checkbox"/> | Contamination <input type="checkbox"/> | Instructions Incomplete/Unclear <input type="checkbox"/> | Part Moved <input type="checkbox"/> | Wrong Stock Pulled <input type="checkbox"/> | | | | | | | |
| Crushing <input type="checkbox"/> | Countersink <input type="checkbox"/> | Misaligned/off center <input type="checkbox"/> | Positioned Wrong <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | |
| Heat Treat <input type="checkbox"/> | Cut Too Short <input type="checkbox"/> | Mislabeled <input type="checkbox"/> | Power Loss/Surge <input type="checkbox"/> | | | | | | | | |
| Inspection Strip in Tube <input type="checkbox"/> | Drawing <input type="checkbox"/> | Misread <input type="checkbox"/> | | | | | | | | | |
| Marks/Chatter <input type="checkbox"/> | Drill Holes <input type="checkbox"/> | Off-set <input type="checkbox"/> | | | | | | | | | |
| Turning Sequence <input type="checkbox"/> | Finish <input type="checkbox"/> | Out of Calibration <input type="checkbox"/> | | | | | | | | | |
| Wave/Twist in Tube <input type="checkbox"/> | Fit/Function <input type="checkbox"/> | Out of Sequence <input type="checkbox"/> | | | | | | | | | |

Picklist Print

Page 1

Thursday, May 15, 2014 3:39:55 PM

Work Order ID: 119343

119343
D3566-13

Parent Item: D3566-13

Parent Item Name: Gasket Fwd

Start Date: 5/15/14

Required Date: 5/15/14

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP Rev:A New Issue 07-03-08 ec
IPP Rev:B Added Drain Holes 07-07-09 JLM
IPP Rev:C As per Rev C 07-09-09 JLM Verified By:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|------------|
| MNEO60S.063 | | Purchased | | No | | 100 | sf | 776.9900 | 0.195 | 5.200001 | ** | 6 | JM14-05-29 |

MNEO60S.063

NEOPRENE SHEET 0.063

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| MAT052 | 776.99 | |
| M126546 | 27.1 | |
| M128266 | 12.29 | |
| M128339 | 737.6 | 128339 |

DQA: _____ Date: _____

QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATEWork Order update only

| | | | | | | | |
|-------------------|--|--|--|--|--|--|--|
| Work Order: _____ | DISPOSITION | AGAINST DEPARTMENT/PROCESS | | | | | |
| Part No. _____ | Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> | Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> | Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> | Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> | | |
| NCR No. _____ | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | | | | |
|---------------------|---|---------|---|--|---|---|
| Landing Gear | Bending <input type="checkbox"/> | General | Bend <input type="checkbox"/> | Folio/Program <input type="checkbox"/> | Outside Dimensions <input type="checkbox"/> | Pressure/Forced Set-up <input type="checkbox"/> |
| | Centre Not Concentric <input type="checkbox"/> | | BQM/Route <input type="checkbox"/> | Grain <input type="checkbox"/> | Over/Under tolerance <input type="checkbox"/> | Temperature/Cure <input type="checkbox"/> |
| | Cracks <input type="checkbox"/> | | Broken/Damage/Defect <input type="checkbox"/> | Hardware <input type="checkbox"/> | Part Incorrect <input type="checkbox"/> | Weld <input type="checkbox"/> |
| | Crimp/Kink/Ripple/Wave <input type="checkbox"/> | | Burrs <input type="checkbox"/> | Inspection Incomplete/Unqualified <input type="checkbox"/> | Part Lost/Missing <input type="checkbox"/> | Wrong Stock Pulled <input type="checkbox"/> |
| | Cuffs <input type="checkbox"/> | | Contamination <input type="checkbox"/> | Instructions Incomplete/Unclear <input type="checkbox"/> | Part Moved <input type="checkbox"/> | |
| | Crushing <input type="checkbox"/> | | Countersink <input type="checkbox"/> | Misaligned/off center <input type="checkbox"/> | Positioned Wrong <input type="checkbox"/> | |
| | Heat Treat <input type="checkbox"/> | | Cut Too Short <input type="checkbox"/> | Mislabeled <input type="checkbox"/> | Power Loss/Surge <input type="checkbox"/> | |
| | Inspection Strip in Tube <input type="checkbox"/> | | Drawing <input type="checkbox"/> | Misread <input type="checkbox"/> | | |
| | Marks/Chatter <input type="checkbox"/> | | Drill Holes <input type="checkbox"/> | Off-set <input type="checkbox"/> | | |
| | Turning Sequence <input type="checkbox"/> | | Finish <input type="checkbox"/> | Out of Calibration <input type="checkbox"/> | | |
| | Wave/Twist in Tube <input type="checkbox"/> | | Fit/Function <input type="checkbox"/> | Out of Sequence <input type="checkbox"/> | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |

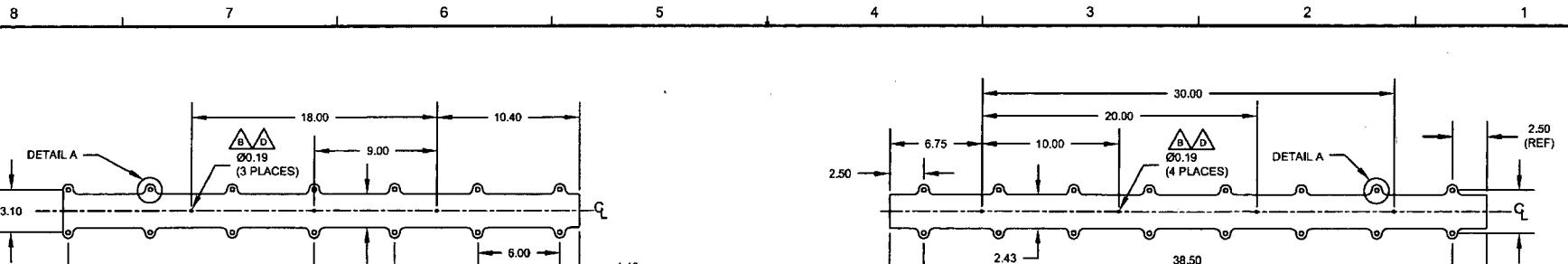
| | | |
|------------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 119343 |
| Description: Gasket | Part Number: | D3566-13 |
| Inspection Dwg: D3566 Rev: C | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

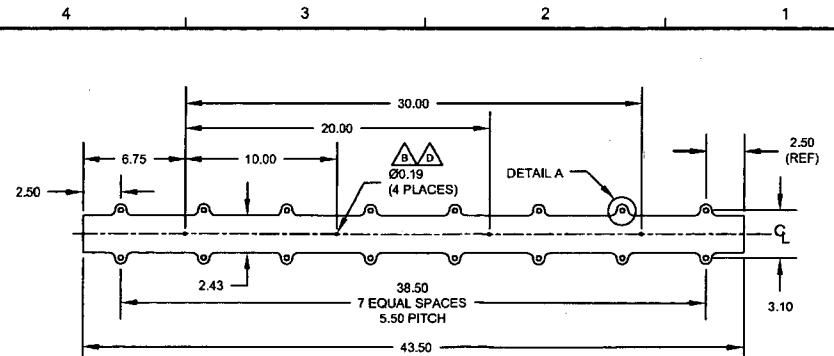
X First Article Prototype

| | | | | | |
|--------------|----------|-------------|-----------|---------------------|-----|
| Measured by: | Jm | Audited by: | DAS 27 | Prototype Approval: | N/A |
| Date: | 14-05-29 | Date: | 14/05/30 | Date: | N/A |

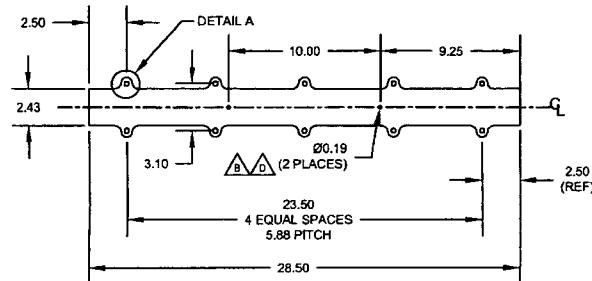
| Rev | Date | Change | Revised by | Approved |
|------------|-------------|-----------------------------------|-------------------|--|
| A | 07.04.20 | New Issue | KJ/JLM | |
| B | 07.07.18 | Dimensions updated per Dwg Rev. B | KJ/JLM | |
| C | 08.09.04 | Dwg Rev updated | KJ/DD |   |



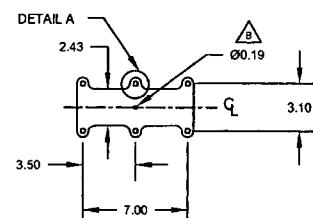
D3566-1 GASKET



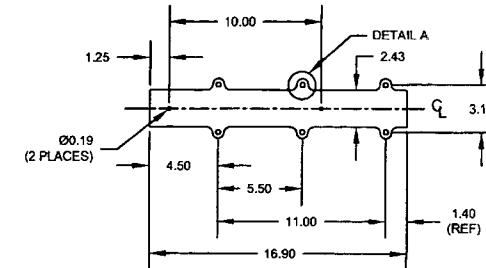
D3566-5 GASKET



D3566-7 GASKET



D3566-13 GASKET



D3566-15 GASKET

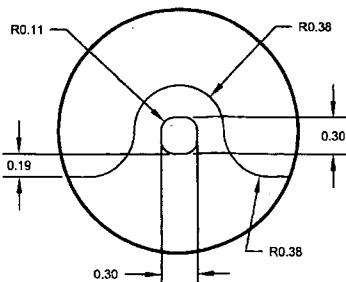
RELEASED

07.04.04

119343 MLJ
1405-21

NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) PARTS ARE SYMMETRIC ABOUT $\frac{1}{2}$



DETAIL A
SCALE 1:1

WEIGHTS:
 D3566-1 0.29 lbs
 D3566-5 0.36 lbs
 D3566-7 0.24 lbs
 D3566-13 0.07 lbs
 D3566-15 0.15 lbs

| | | | |
|--|---|--|--------------|
| C | UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); A8: UPDATE NOTES; A8, B2: ADD D3566-15; A5: INCREASE SIZE OF DETAIL A; | CB | 07.08.21 |
| B | ADD DRAIN HOLES | PH | 07.04.17 |
| A | NEW ISSUE | PH | 06.12.18 |
| REV. | DESCRIPTION | | |
| DESIGN | <i>A1</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | A |
| DRAWN | <i>CB</i> | REV. C | |
| CHECKED | <i>PH</i> | DRAWING NO. D3566 | SHEET 1 OF 1 |
| MFG. APPR. | <i>PH</i> | APPROVED | SCALE 1:8 |
| APPROVED | <i>PH</i> | TITLE GASKET | |
| DE APPR. | <i>PH</i> | DATE 07.08.21 | |
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